

**Work Order ID 68962**




Tuesday, April 26, 2011 1:46:33 PM



Page 1




Item ID: D3290-041 Accept  Setup Start   
Revision ID:  
Item Name: Replacement Window Assembly Stop   
Start Date: 4/26/2011 Start Qty: 8.00  Cust Item ID:  
Required Date: 4/29/2011 Req'd Qty: 8.00  Customer:

**Reference:**

Approvals: Process Plan:  Date: 4-24-11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3290	DEO Rev C1


100  0.00  
Waterjet FLOW WATER JET  
Memo 0.00  
FLOW CNC Waterjet 1-Cut as per Dwg D3290 ( use prog. for D3290-1)  
Dwg Rev:   
Prog Rev:   
2-Deburr if necessary

PB1-5-5



110  0.00  
QC QC2- Inspect parts off machine FAI/FAIB  
Memo 0.00  
Quality Control

PB1-5-5

120  0.00  
QC QC8- Inspect parts - second check  
Memo 0.00  
Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 4/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				88	0	11/05/09	
140  Powdercoat Powder Coating M116964	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 11:10 OVEN TEMPERATURE: 320 °F FINISH TIME: 11:40	0.00  0.00				88	0	11/05/09	
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				88	0	11/05/09	

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

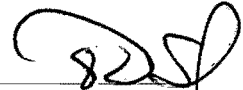
Page 3

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							11/05/13
Small Fab	Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap								
170  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
180  Packaging	Identify as per dwg & Stock Location: <u>219</u>	0.00							
Packaging	Memo	0.00							11/5/16 

W/O:		WORK ORDER CHANGES					
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**Work Order ID 68962**

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Page 4

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 4/26/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/18

11-05-15

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Tuesday, April 26, 2011 1:46:40 PM

Page 1

Work Order ID: 68962

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly




Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B005.05.25 Added Step 11 KJ/JLM  
 IPP C006.05.09 Ecn 798 EC  
 IPP Rev:D Now on Waterjet 06-06-16 JLM  
 IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	372.0000	3.75	31.57895			
<div> <div>Location</div> <div>MAT021</div> <div>116308</div> <div>117285</div> </div> <div> <div>Loc Qty</div> <div>372</div> <div>36</div> <div>336</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2126  Seal		Manufactured	No			160	f	78.2586	6.5	52			
<div> <div>Location</div> <div>ST405</div> <div>57106</div> <div>64918</div> </div> <div> <div>Loc Qty</div> <div>78.2586</div> <div>4</div> <div>74.2586</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
(D2126-0780) cut qty (1) at 78.00" as per dwg ***per kit***													
D3290-3  Window		Manufactured	No			160	Each	0.0000	1	8			

B67602

x5

B69556

x3

DL  
 11/05/13  
 DL  
 11/05/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	67962
<b>Description:</b> Window Frame		<b>Part Number:</b>	D3290-1
<b>Inspection Dwg:</b> D3290 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓		T 1801	
14.00	+/-0.030	14.00	✓		T	
Ø0.171	+0.005/-0.001	.172	✓		V 1802	
1.50	+/-0.030	1.509	✓		V	
1.11	+/-0.030	1.104	✓		V	
10.10	+/-0.030	10.10	✓		T	
18.50	+/-0.030	18.50	✓		T	
0.063	+/-0.010	.062	✓		✓	
R3.00	+/-0.030	3.00	✓		R.G.	
R4.50	+/-0.030	4.50	✓		R.G.	
Ø0.257	+0.006/-0.001	.257	✓		V	
13.61	+/-0.030	13.61	✓		T	

<b>Measured by:</b> R	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-5-15	<b>Date:</b> 11/05/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	
D	09.11.04	Dimension 0.063 was 0.040	KJ	

W/O:		WORK ORDER CHANGES					
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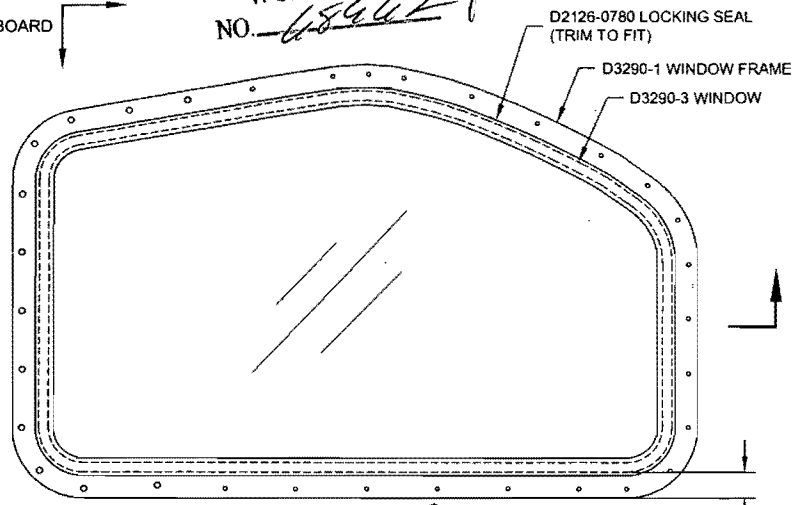
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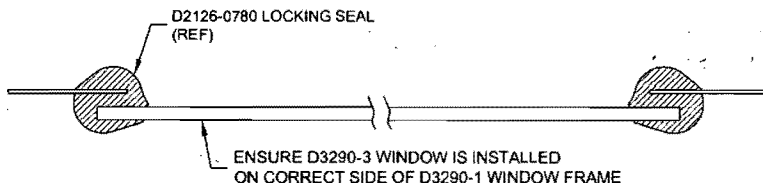
**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY 6  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68962 *11-09-26*

FWD  
INBOARD



1.10 (TYP)  
DIST. FROM FRAME  
EDGE TO WINDOW

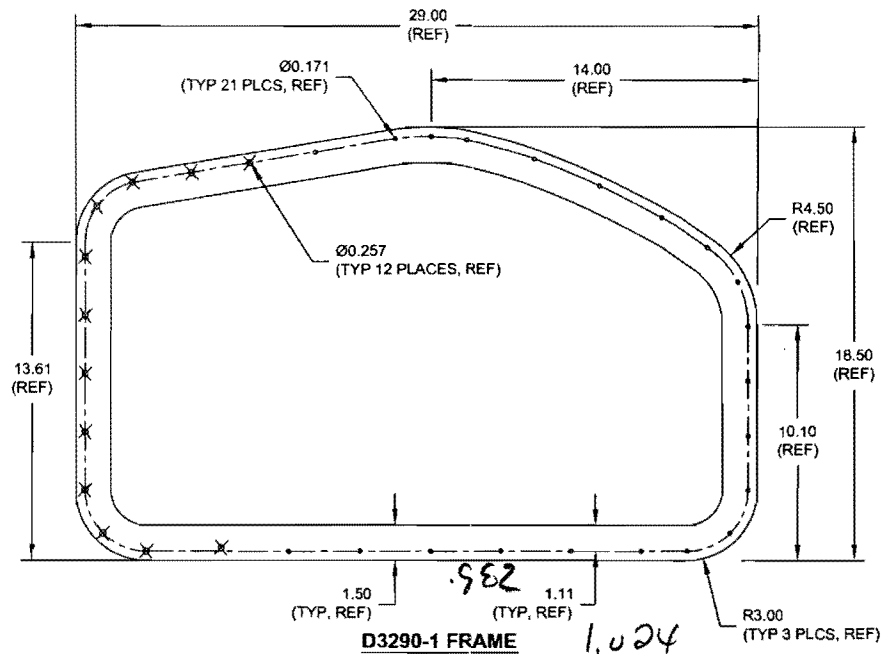


SECTION A-A  
NTS

### D3290-041 REPLACEMENT WINDOW ASSEMBLY

**D3290-041 NOTES:**  
1) WEIGHT: 3.66 LBS

**GENERAL NOTES:**  
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
2) UNITS: INCHES UNLESS OTHERWISE NOTED



### D3290-1 FRAME

#### D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.040)  
OR  
5052-H32 ALUMINUM SHEET 0.040 THICK  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1  
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED  
07.07.24  
DEO ATTACHED

UNDER REVIEW

*4/09/07-18*  
*MIR 07-057*  
*69/10/19*

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290  
SHEET 1 OF 2

TITLE  
REPLACEMENT WINDOW ASSEMBLY  
SCALE 1:5

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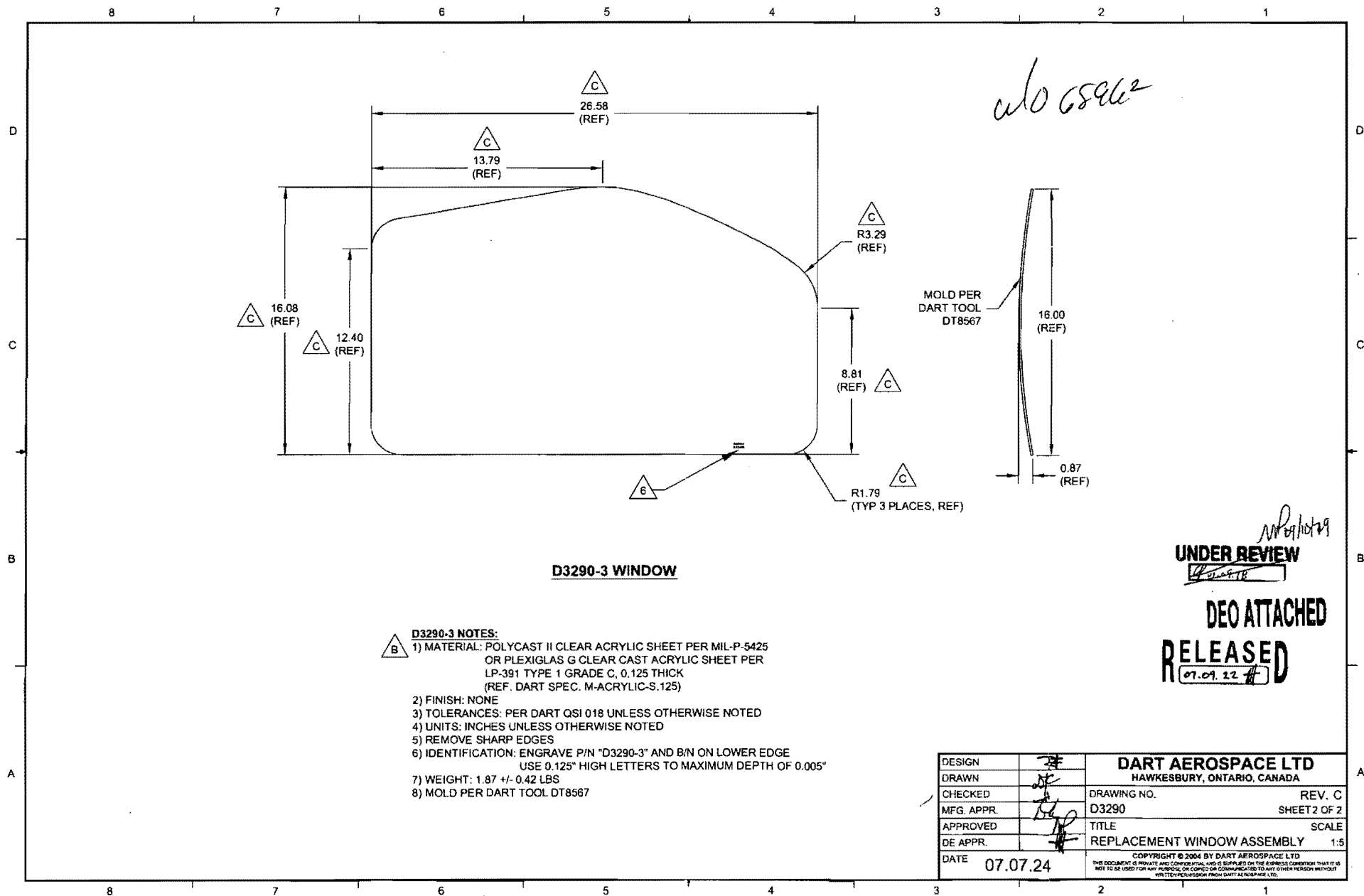
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>b</i>	MFG. APPR. <i>FE</i>	APPROVED <i>AP</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

**PURPOSE:**

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

**CHANGE:**

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

*u/b 68962*

**D3290-1 NOTES**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)  
 OR  
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)  
 PER AMS-QQ-A-250/8 OR AMS 4016  
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

**RELEASED**  
 2009 -10- 09  
*WMP*

W/O:		WORK ORDER CHANGES					
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